



Designation: C1384 – 23

Standard Specification for Admixtures for Masonry Mortars¹

This standard is issued under the fixed designation C1384; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope*

1.1 This specification pertains to admixtures for masonry mortars. Admixtures are substances other than Specification C270 prescribed materials of water, aggregate, and cementitious materials that are used to improve one or more of the recognized desirable properties of conventional masonry mortar.

1.2 This specification does not cover coloring pigments.

Note 1—Information on coloring pigments can be found in Specification C979/C979M.

1.3 This specification does not cover additives that are added to the cementitious materials during the manufacture of the cementitious materials.

1.4 Acceptance of an admixture is based on its performance in an admixed mortar. Acceptance of the admixed masonry mortar is based on attainment of performance either equivalent to that required for conventional mortar or improved performance of one or more indicated properties, while maintaining required performance levels for other properties.

1.5 The text of this standard refers to notes and footnotes that provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of the standard.

1.6 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

Note 2—The testing laboratory performing the test methods referenced in this specification should be evaluated in accordance with Practice C1093.

1.7 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

C144 Specification for Aggregate for Masonry Mortar

C270 Specification for Mortar for Unit Masonry

C305 Practice for Mechanical Mixing of Hydraulic Cement Pastes and Mortars of Plastic Consistency

C403/C403M Test Method for Time of Setting of Concrete Mixtures by Penetration Resistance

C723 Practice for Chemical-Resistant Resin Grouts for Brick or Tile (Withdrawn 2021)³

C780 Test Methods for Preconstruction and Construction Evaluation of Mortars for Plain and Reinforced Unit Masonry

C979/C979M Specification for Pigments for Integrally Colored Concrete

C1072 Test Methods for Measurement of Masonry Flexural Bond Strength

C1093 Practice for Accreditation of Testing Agencies for Masonry

C1152/C1152M Test Method for Acid-Soluble Chloride in Mortar and Concrete

C1180 Terminology of Mortar and Grout for Unit Masonry

C1218/C1218M Test Method for Water-Soluble Chloride in Mortar and Concrete

C1403 Test Method for Rate of Water Absorption of Masonry Mortars

C1437 Test Method for Flow of Hydraulic Cement Mortar

3. Terminology

3.1 Terminology defined in Terminology C1180 shall apply for this specification.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *admixed mortar, n*—masonry mortar that deviates from those combinations of materials recognized by Specification C270 in that it also contains an admixture.

¹ This specification is under the jurisdiction of ASTM Committee C15 on Manufactured Masonry Units and is the direct responsibility of Subcommittee C15.30 on Specifications for Mortars and Grouts.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on www.astm.org.

*A Summary of Changes section appears at the end of this standard

3.2.2 *admixture*, *n*—substance other than the Specification C270 prescribed materials of water, aggregate, and cementitious materials that is added to a masonry mortar to modify one or more properties of the conventional masonry mortar.

3.2.3 *bond enhancer*, *n*—admixture used to increase the bond strength between the masonry mortar and the masonry unit.

3.2.4 *reference mortar*, *n*—mortar of the same composition as an admixed mortar except that the reference mortar does not include the admixture and may contain a different amount of water to obtain an equivalent flow or penetration as the admixed mortar.

3.2.5 *set accelerator*, *n*—admixture used to shorten the time of setting of a masonry mortar.

3.2.6 *set retarder*, *n*—admixture used to lengthen the time of setting of a masonry mortar.

3.2.7 *water repellent*, *n*—admixture used to decrease the rate of water absorption of the hardened masonry mortar.

3.2.8 *workability enhancer*, *n*—admixture used in a masonry mortar to increase the ease of being worked and used.

3.2.8.1 *Discussion*—Workability is a combination of several properties, including: plasticity, consistency, cohesion, adhesion, water retentivity, setting characteristics, and its capacity to remain satisfactory under the influence of masonry unit suction and ambient environmental conditions. Many of these properties have defied exact laboratory measurement. The mason can best assess workability by observing the response of the mortar to the trowel and the masonry unit. For further discussion on workability, see the Appendix of Specification C270.

4. Classification

4.1 Admixtures are classified by their effect on the performance characteristics of conventional masonry mortars. Admixed mortars are classified by their modified properties, as compared to a reference mortar. The following classifications are recognized:

- 4.1.1 Bond Enhancer.
- 4.1.2 Workability Enhancer.
- 4.1.3 Set Accelerator.
- 4.1.4 Set Retarder.
- 4.1.5 Water Repellent.

5. Materials

5.1 *Cementitious Materials*—Cementitious materials shall conform to those allowed in Specification C270 for proportion specification mortars.

5.2 *Sand*—The fine aggregate used in the tests shall conform to the requirements of Specification C144. The sand used in preparing the mortars for all tests shall be from the same delivery.

6. Chemical Composition

6.1 The admixture shall not react adversely with embedded or attached materials common to masonry.

Note 3—Currently, there is no standard test method for determining the

corrosion potential of masonry mortars toward embedded and attached materials. Nonetheless, the admixture shall not be offered for sale if the manufacturer has evidence that the admixture does react adversely with embedded or attached materials common to masonry.

6.2 At the maximum recommended dosage, the mortar admixture shall add not more than 65 ppm (0.0065 %) water-soluble chloride, or 90 ppm (0.0090 %) acid-soluble chloride to the mortar's overall chloride content as determined by testing of the reference and admixed mortars in accordance with 9.1.1.

7. Physical Properties

7.1 All modified masonry mortars shall comply with the property specification requirements of Specification C270. In addition, the admixed mortars shall conform to all of the specific classification requirements in Table 1 for which the admixture is obtaining qualification. Unless more specimens are required by a specific test method, a minimum of three specimens shall be tested and the results averaged. These result averages shall meet the requirements of this section.

7.2 Admixture compliance tests shall be the responsibility of the manufacturer of the admixture. These compliance tests shall be completed within the past five (5) years and prior to any admixture composition change.

8. Mortar Types and Proportions

8.1 Design the reference mortar to be a specific type of cement/lime, mortar cement, or masonry cement mortar in conformance with the proportion specification of Specification C270 except that the aggregate ratio shall be fixed at three times the sum of the separate volumes of cementitious materials. In addition, the aggregate shall meet the requirements in 5.2.

8.2 The corresponding admixed mortars shall have the same composition as the reference mortars but also shall include the admixture, and the water content shall be adjusted to yield the flow or penetration appropriate for each test method. The admixture dosage rate, time of addition, and mixing sequence shall follow the manufacturer's recommendations.

8.3 A complete set of tests shall be run for all applicable cement/lime, mortar cement, and masonry cement types for which the admixture is to be qualified.

9. Test Methods

9.1 For all required tests, test both the reference mortar and the admixed mortar in accordance with the following test methods:

9.1.1 *Soluble Chloride Content*—Prepare six mortar cubes in accordance with the specimen preparation section of Test Method C1403 including the drying procedure, except that mortar proportions shall be as specified in Section 8 and aggregates shall be as specified in 5.2. After 28 days of age, determine the water-soluble chloride content of three cubes, as percent chloride by mass of mortar, in accordance with Test Method C1218/C1218M except increase the sample size to 15 g instead of the 10 g specified in Test Method C1218/C1218M. Determine the acid-soluble chloride content of the other three cubes, as percent chloride by mass of mortar, in accordance

TABLE 1 Physical Requirements^A

	Bond Enhancer	Workability Enhancer	Set Accelerator	Set Retarder	Water Repellent
Compressive strength, min % of reference:					
7 day	80	80	80	70	80
28 day	80	80	80	80	80
Water retention, min % of reference:	report	100	report	report	report
Air content of plastic mortar, %	report	report	report	report	report
Board life, min % of reference	report	120	report	120	report
Time of setting ^B , allowable deviation from reference, h: min:					
Initial: at least	1:00 earlier	1:00 ^C later	...
not more than	1:00 earlier nor 1:30 later	1:00 earlier nor 3:30 later	3:30 earlier	8:00 ^C later	1:00 earlier nor 1:30 later
Final: at least	1:00 earlier
not more than	1:00 earlier nor 1:30 later	1:00 earlier nor 3:30 later	...	8:00 ^C later	1:00 earlier nor 1:30 later
Flexural bond strength, min % of reference	110
Rate of water absorption max % of reference 24 h:					
28 days	50

^A The values in the table include allowance for normal variation in test results. In addition to meeting the requirements in this table, all admixed mortars must meet the property requirements of Specification C270.

^B All time of setting tests shall be performed at 23 ± 3°C (73.4 ± 5.4°F), except those for set accelerators, which shall be performed at 5 ± 2°C (41 ± 3.6°F) as specified in 9.1.5.

^C The manufacturer's maximum recommended dosage rate shall be used when testing the initial and final set times for a set retarder.

with Test Method C1152/C1152M except increase the sample size to 15 g instead of the 10 g specified in Test Method C1152/C1152M.

9.1.2 *Compressive Strength*—Prepare and test mortar in accordance with Specification C270, except that mortar proportions shall be as specified in Section 8 and aggregates shall be as specified in 5.2. Test three specimens at 7 days and three specimens at 28 days.

9.1.3 *Water Retention*—Prepare and test mortar in accordance with Specification C270, except that mortar proportions shall be as specified in Section 8 and aggregates shall be as specified in 5.2.

9.1.4 *Air Content of Plastic Mortar*—Prepare mortar and determine air content of the plastic mortar in accordance with Specification C270 except that mortar proportions shall be as specified in Section 8 and aggregates shall be as specified in 5.2. Calculate the air content to the nearest 0.1 % as follows:

$$D = \frac{(W_1 + W_2 + W_3 + W_4 + W_5 + V_w)}{\frac{W_1}{P_1} + \frac{W_2}{P_2} + \frac{W_3}{P_3} + \frac{W_4}{P_4} + \frac{W_5}{P_5} + V_w} \quad (1)$$

$$A = 100 - \frac{W_M}{4D}$$

where:

D = density of air-free mortar, g/cm³,
 W_1 = weight of portland cement, g,
 W_2 = weight of hydrated lime, g,
 W_3 = weight of mortar cement or masonry cement, g,
 W_4 = weight of sand, g,
 W_5 = weight of mortar admixture, g,
 V_w = mL of water used,
 P_1 = density of portland cement, g/cm³,
 P_2 = density of hydrated lime, g/cm³,
 P_3 = density of mortar cement or masonry cement, g/cm³,
 P_4 = density of sand, g/cm³,
 P_5 = density of mortar admixture, g/cm³,
 A = volume of air, %, and
 W_M = weight of 400 mL of mortar, g.

9.1.5 *Board Life*—Test mortar in accordance with Test Methods C780, Annex A2 *Test Method for Consistency Retention (Board Life) of Mortars for Unit Masonry Using a Cone Penetrometer* or, alternately, Annex A3 *Test Method for Consistency and Consistency Retention (Board Life) of Masonry Mortars Using a Modified Concrete Penetrometer*, except for the modifications in this section. The mortar proportions shall be as specified in Section 8 and aggregates shall be as specified in 5.2. Prepare the mortar in accordance with the procedures of Test Methods C780, modifying those as appropriate when the admixture is added to the mortar. Mix the mortar for 5 min,



timing from when water and cementitious materials are combined or as recommended by the manufacturer. The mixer used shall conform to that described in Practice C305, or to that described in Practice C723, or shall be a paddle-type field mortar mixer.

9.1.5.1 If Test Methods C780, Annex A2 is used, prepare the mortar to have an initial penetration of 60 ± 5 mm. Measure the initial penetration within 2 min from the completion of the mixing. Record the initial penetration as P_0 and the time of this measurement as T_0 . Test the sample using the disturbed sample procedure and measure the penetration at 15-min intervals until the penetration is less than 70 % of P_0 . Record as T_f the interpolated time at which the penetration equals 70 % of P_0 . Board life is defined as $(T_f - T_0)$, in minutes.

9.1.5.2 If Test Methods C780, Annex A3 is used, prepare the mortar to have an initial penetration resistance (P_0) of either 0.94 ± 0.05 psi or 1.24 ± 0.05 psi as specified in the Annex A3. Board life is defined as T_f as specified in the Annex A3.

9.1.6 *Time of Setting*—Test mortar in accordance with Test Method C403/C403M except for the modifications in this section. The mortar proportions shall be as specified in Section 8 and aggregates shall be as specified in 5.2. Prepare the mortar in accordance with the procedures of Test Methods C780, modifying those as appropriate when the admixture is added to the mortar. Mix the mortar for 5 min, timing from when water and cementitious materials are combined or as recommended by the manufacturer. The mixer used shall conform to that described in Practice C305, or to that described in Practice C723, or shall be a paddle-type field mortar mixer. Prepare the mortar to have a flow of 110 ± 5 mm as determined by Test Method C1437. Prepare and test the mortar at a temperature of $23 \pm 3^\circ\text{C}$ ($73.4 \pm 5.4^\circ\text{F}$) for all admixture classifications except set accelerators. Prepare and test the mortar at a temperature of $5 \pm 2^\circ\text{C}$ ($41 \pm 3.6^\circ\text{F}$) for set accelerators.

9.1.7 *Flexural Bond Strength*—Prepare and test mortar in accordance with the Test Method for Laboratory-Prepared Specimens in Test Methods C1072 except as modified in this section. Use the mortar proportions as specified in Section 8 and aggregates as specified in 5.2. Test a total of 30 mortar joints consisting of 10 mortar joints from each of three separate mortar batches.

9.1.8 *Rate of Water Absorption*—Prepare and test mortar in accordance with Test Method C1403 except that mortar samples shall be tested at 28 days of age, mortar proportions shall be as specified in Section 8, and aggregates shall be as specified in 5.2.

10. Product Marking

10.1 When the admixture is delivered in packages or containers, the admixture classification, the trade name of the admixture, the name of the manufacturer, and the weight of the admixture shall be marked clearly on each package or container.

10.2 If the total chloride content of the admixture is greater than 0.1 % by mass, then the admixture package or container shall have a label stating that the admixture contains chloride. In this case, the admixture package or container shall contain a label stating that at the maximum recommended dosage, the mortar admixture shall add not more than 65 ppm (0.0065 %) water-soluble chloride or 90 ppm (0.0090 %) acid-soluble chloride to the mortar's overall chloride content when tested according to this specification. If the admixture contains less than or equal to 0.1 % by mass of total chloride, then no label referring to chloride is necessary.

11. Report

11.1 Report the following information:

11.1.1 Trade name, manufacturer, classification(s) of the admixture, and the type(s) of mortar for which the admixture is qualified.

11.1.2 Results of the tests specified in Sections 6 and 7 for each type of mortar for which the admixture is qualified. Include the results for both the reference mortar and the admixed mortar. Also, include the flow or penetration value of the mortar used in each test as specified in each test method.

11.1.3 Brand name, manufacturer, and type of cement used in the test evaluation.

11.1.4 Brand name, manufacturer, and type of lime, if any, used in the test evaluation.

11.1.5 Description of, and test data on, the sand used in the test evaluation.

11.1.6 The mix design and weight of each component, including water, used in the mortar for each test batch. For those batches which contain an admixture, include the admixture dosage rate and time of addition.

12. Keywords

12.1 absorption; absorption rate; admixed mortar; admixture; bond enhancer; masonry mortar; set accelerator; set retarder; water repellent; workability enhancer



SUMMARY OF CHANGES

Committee C12 has identified the location of selected changes to this standard since the last issue (C1384 – 18th) that may impact the use of this standard. (December 1, 2023)

(1) Added 1.5 on non-mandatory notes and footnotes (excluding those in tables and figures).

(2) Updated Test Methods C780 Annex references in 9.1.5 to agree with current edition of Test Methods C780.

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